










Date: Wednesday, 11/21/2007 12:44:45 PM
 User: Kim Johnston

Process Sheet

3

Customer: CUL-DAR001 Dart Helicopters Services	Drawing Name: SKID TUBE ASSEMBLY
Job Number: 35907A	Part Number: D20563405 -041
Estimate Number: 12520	Drawing Number: D2580 REV D
P.O. Number:	Project Number: N/A
This Issue: 11/21/2007 S.O. No.:	Drawing Revision: D
Prsht Rev: NC	Material:
First Issue: 1/1 Type: LANDING GEAR	Due Date: 1/15/2008 Qty: 1 Um: Each
Previous Run: 35906A	
Written By: <u>7.11.21</u>	
Checked & Approved By: <u>7.11.21</u>	
Comment: Rev: C Revised Steps 06-09-06 JLM Rev: D Added SS Wearplates & Gaskets 07-07-09 JLM	
Additional Product	
Job Number: 	
Seq. #: 1.0	Machine Or Operation: DC
Description: DOCUMENT CONTROL	
	
	
Comment: DOCUMENT CONTROL Photocopy D205-634 bluefile & type labels per PPP D205-634-035 CHG002 N/A 7-11-27	
2.0	D25001190
Ext'n - 1" Beam Tube 4"	
	
	
Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)	
Pick:	
Qty	Part Number Description Batch
1	D2500-1-190 Skid Tube Extrusion 34129 SL 7-11-27
3.0	D2596
205 Web	
	
	
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)	
Pick:	
Qty	Part Number Description Batch
1	D2596 205 Web 35996 SL 7-11-27
4.0	LANDING GEAR 1
LANDING GEAR RESOURCE 1	
	
	
Comment: LANDING GEAR RESOURCE 1	
1- Inspect mat'l D2500-1-190 for damage	
2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends	
3-Drill pilot holes using drill jig DT 8149	
4-Acid etch and Alodine tube per QSI 005 4.1	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:44:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35907A

Part Number: D205634045 -041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 105489

Sikaflex expire date: 6-7-1

Start Time: 2:00 Date: 7-11-27

Fin Time: 4:00 Date: 7-11-28

SL 7-11-27

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL/SK 7-11-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

BE 07/12/12

N/A 2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

N/A 3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill pilot holes for aft cap using DT8215. ***DO NOT OPEN TO FINISH SIZE***

BE 07/12/12

N/A 5-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 locating from aft cap hole and aft saddle hole.

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP




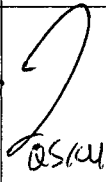
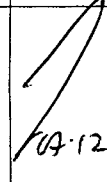
07/12/12

P70

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-07	5.0	Aft end cut too short. See NCR 271 R.C: Human error		- Lubricate 6061-T6 RB plug 0.0050 x 1ST. M <u>105071</u> Qty <u>42</u> - plug 0.009183 holes and weld per Q31004 M <u>106035</u> AIR - grind flush.	 07-12-12	 07-12-12	 07-12-12	 07-12-07

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:44:46 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35907A

Part Number: D205634045 -041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2576-3

Step

*B23464 **

BE 07-12-12

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

20

D2579

Spacers

*B34789 **

BE 07/12/12

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 07/12/12

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m 106035

BE 07/12/12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m 106035

BE 07/12/12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

7-12-19

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13, 14 AND 15 (LEAVE AT

0.564" AS PER DEO 9183)*****

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

SL 7-12-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 35907A

Part Number: D205634045 -041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

FD 07-12-20 ①

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FD 12/21 ①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FD/a.m 07/12/27 ①

14.0

POWDER COATING

POWDER COATING

Powder coat white per QSI005
4.3.5.1

Comment: POWDER COATING

Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

a.m 07-12-27 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 07/12/27 ①

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B.34349

a.m 07.12.27 ①

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: m100188

a.m 07.12.27 ①

18.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: n 104374

a.m 07.12.27 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35907A

Part Number: D205634045 -041

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

ALS71032130

Insert



ALS 41032130 mi 2008/1/14



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Insert

Batch: m105729

a.m 07.12.27

0

20.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch: m106431

a.m 07.12.27

0

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B32744

a.m 07.12.27

0

22.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B335788

B34354

a.m 07.12.27

0

23.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: B335788

a.m 07.12.27

0

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B33454

a.m 07.12.27

0

25.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: B34805

a.m 07.12.27

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/12/27	20.1	AN960 C10L 50 x Batch: M106575 M106574 in 2008/1/14						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35907A

Part Number: D20563405 -041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 334807

A.M 07.12.27 ①

27.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 336111

A.M 07.12.27 ①

28.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: 327168

A.M 07.12.27 ①

29.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: 333450

A.M 07.12.27 ①

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M105585

Sikaflex expire date: 08-07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M105585

Sikaflex expire date: 08-07

A.M 07.12.27 ①

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M106332

A.M 08.01.02

Batch:

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:44:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 35907A

Part Number: D205634045-041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC5

INSPECT WORK TO CURRENT STEP



08/01/02 @



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045-041

Location:

PPP Rev: H

8/01/02 SP



33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/1/4

W

35907A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

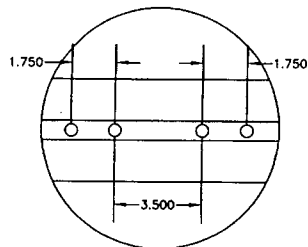
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF NO. TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35907A

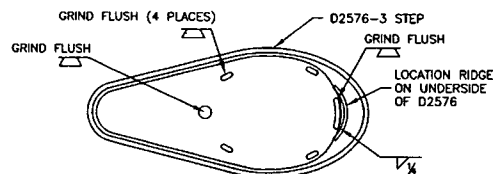
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DETAIL A
SCALE 5:24

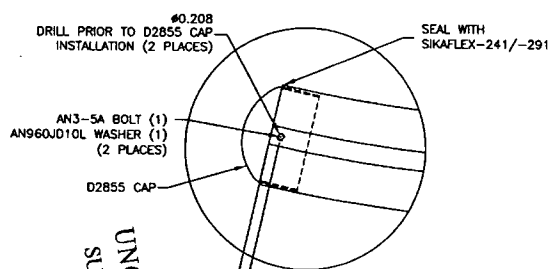


DETAIL B
SCALE 5:24

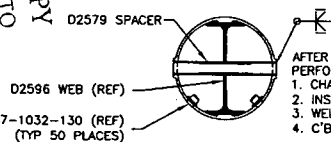


RELEASED
07-08-18

DETAIL C
SCALE 5:24

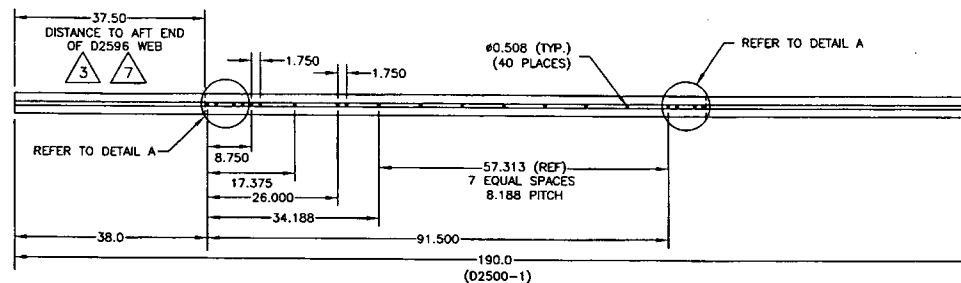


SECTION D-D
SCALE 5:24

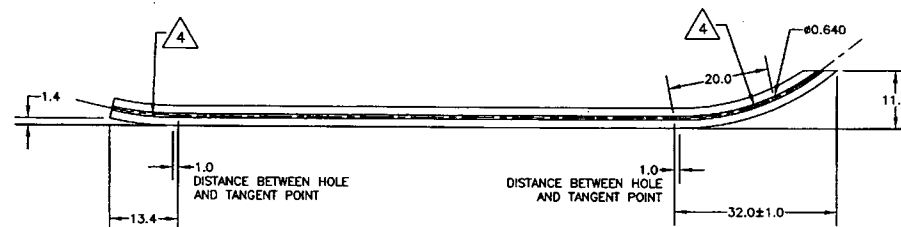


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

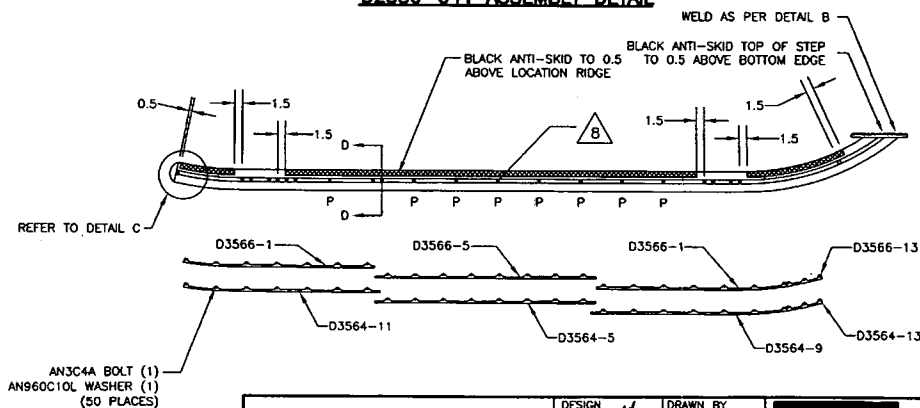
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

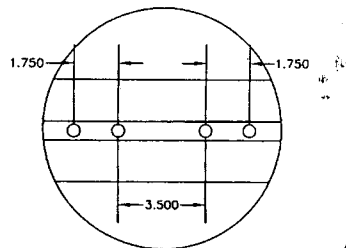
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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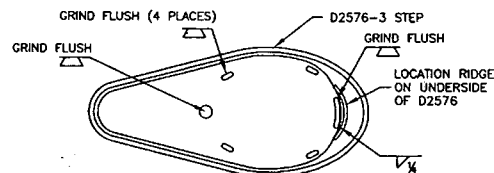
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARWESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

DETAIL E
SCALE 5:24

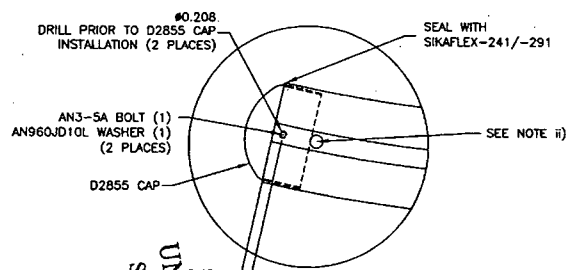


DETAIL F
SCALE 5:24

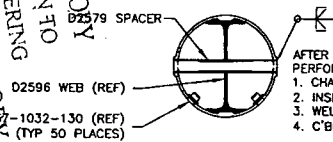


RELEASED
07-18-18

DETAIL G
SCALE 5:24

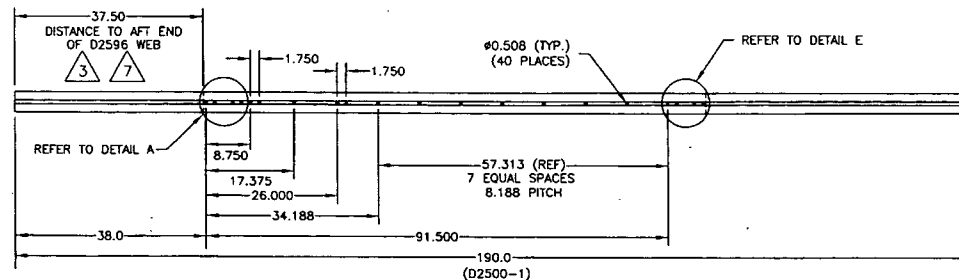


SECTION H-H
SCALE 5:24

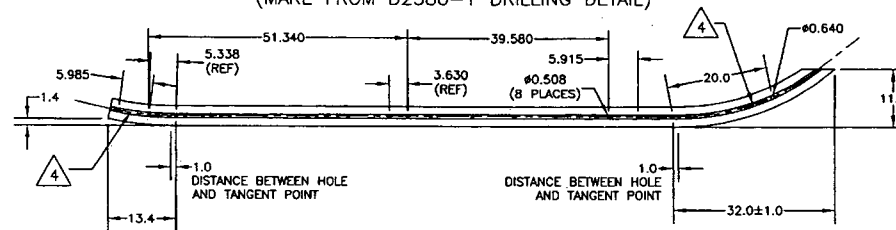


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

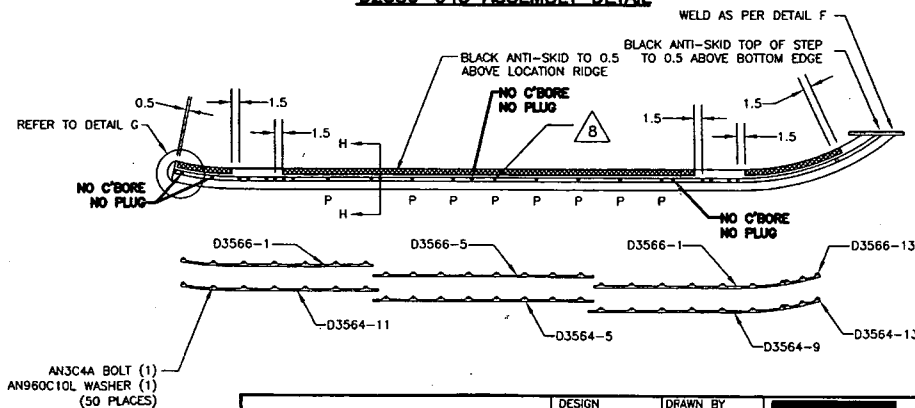
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DART AEROSPACE LTD.

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

NO. 133

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure ti
Part number and Job number D205 634 011 / B35642

TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS ti
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-11-27

Qualifier P. J. D.

Date: Wednesday, 11/21/2007 12:44:27 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKID INSTALLATION KIT
 Job Number : 35907
 Estimate Number : 12519
 P.O. Number :
 This Issue : 11/21/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 35906
 Part Number : D205634015 041
 Drawing Number : IIN D205-634 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 1/15/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 00-04-04 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC

DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP205-634-015 041 CHG 004 002

2.0 35907A

SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

3.0 K10003

D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 D205-634-011 Saddle Kit

4.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D205-634-015
 Location: _____
 PPP Rev: _____

REFERENCE ONLY

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

